

Date: Thursday, 8/23/2007 11:52:38 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	PEDAL ASSEMBLY
Job Number	34237			
Estimate Number	10504			
P.O. Number			Part Number	D3204041
This Issue	8/23/2007	S.O. No. :	Drawing Number	D3204 REV. A1
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : LARGE FAB ASSY	Drawing Revision	A1
Previous Run	32822		Material	:
Written By			Due Date	9/3/2007
Checked & Approved By		<u>07.08.23</u>	Qty:	
Comment	EstC	05.08.11	Added Step 25	KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D32041	Tube
Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
Tube		
Pick:		
Qty	Part Number	Description
1	D3204-1	Tube
		Batch
		<u>B25031</u> → 2x
		<u>B35873</u> → 1
✓		<u>MF</u>
2.0	D32043	Arm
Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
Arm		
Pick:		
Qty	Part Number	Description
1	D3204-3	Arm
		Batch
		<u>B32840</u> → 3
✓		<u>MF</u>
3.0	D32045	Arm
Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
Arm		
Pick:		
Qty	Part Number	Description
1	D3204-5	Arm
		Batch
		<u>B32841</u> → 3
✓		<u>MF</u>
4.0	D32049	Pedal
Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
Pedal		
Pick:		
Qty	Part Number	Description
1	D3204-9	Pedal
		Batch
		<u>B32842</u> → 3
✓		<u>MF 08/01/30</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		DEW						

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:38 AM
User: Kim Johnston

Process Sheet

44704

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 34237

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D320411

Plate



(Pl) →

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3204-11	Plate	B32839 → 3



B32839 → 3

8/08/01/30

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. ✓
- 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. ✓
- 3- Use JB weld compound to plug the hole after assembly. ✓
- 4- Grind JB weld flush after it is cured. ✓

Identify as D3204-041

8/08/01/30

3x

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8/08/01/30

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/01/30

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8/08/01/30

10.0 POWDER COATING

POWDER COATING



M106442

3X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

8/08/01/30

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



98

Comment: INSPECT POWDER COAT

8/08/01/30

X2

D3204-13 B35970 → 6x 8/08/01/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/02/01	5.1	ADD D3204-13 B# 35970 ADD S/cd to Due Parts from stock	SG	08/02/01	*6	W	08/02/01	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/01
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/01	5.1							

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 34237

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D32047 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D3204-7	Bushing	B 35632

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AS 08/02/06 RS

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/14

Job Completion



AS 2008/2/14

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

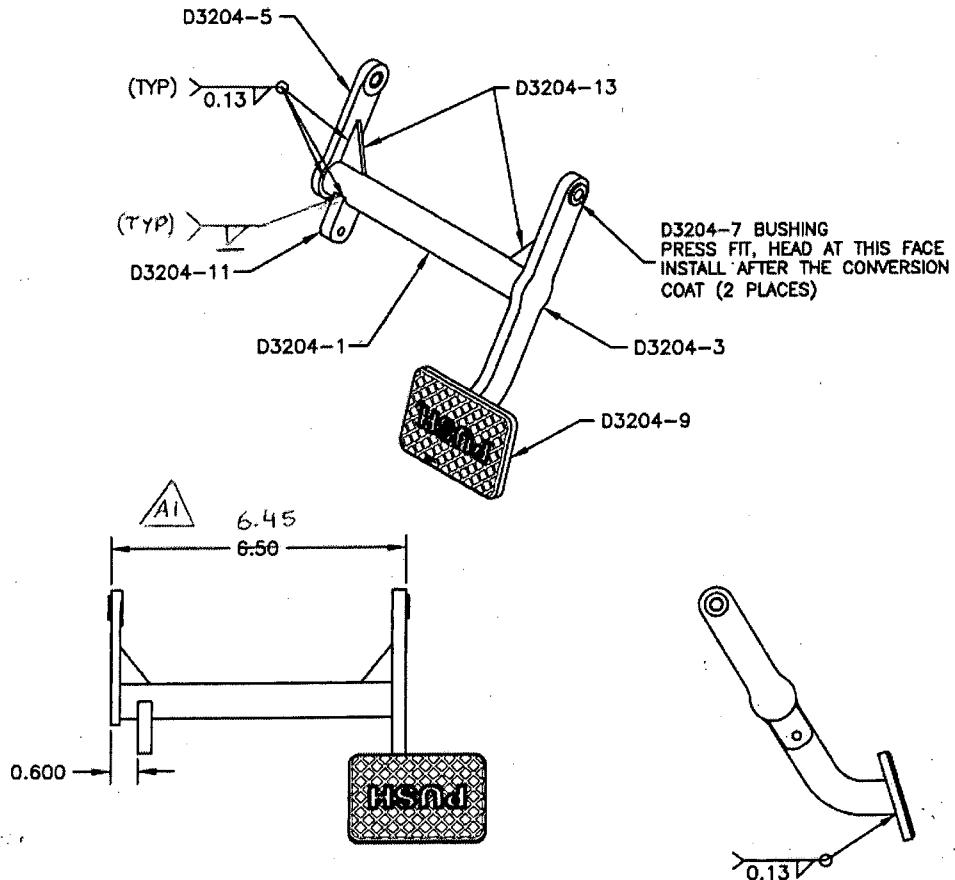
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30**D3204-041 RELEASE PEDAL ASSEMBLY**NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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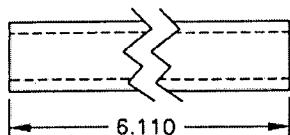
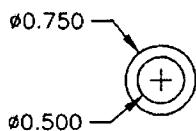
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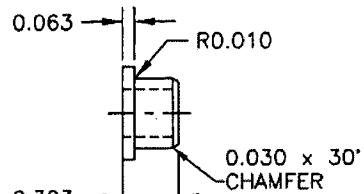
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DATE	04.01.27	REV. A SHEET 2 OF 3 TITLE RELEASE PEDAL ASSEMBLY SCALE NTS

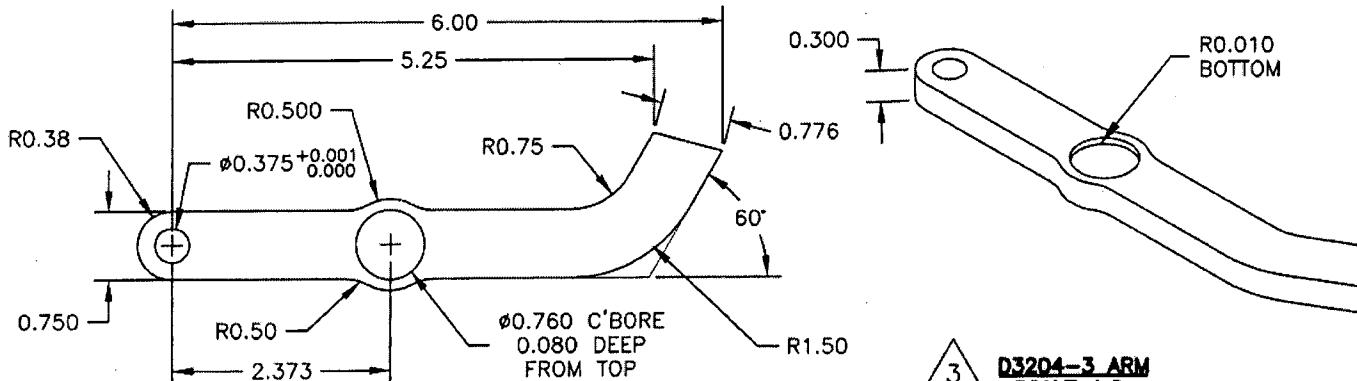
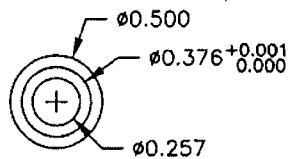
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04.04.05



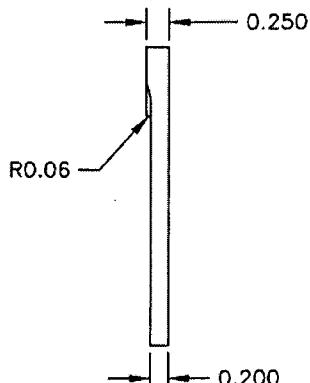
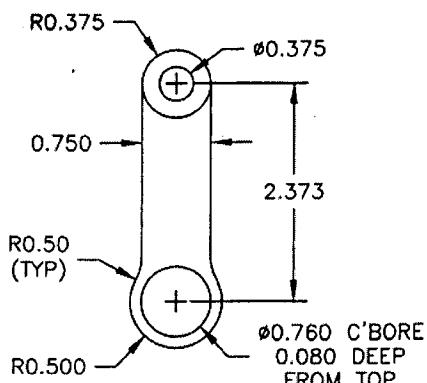
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



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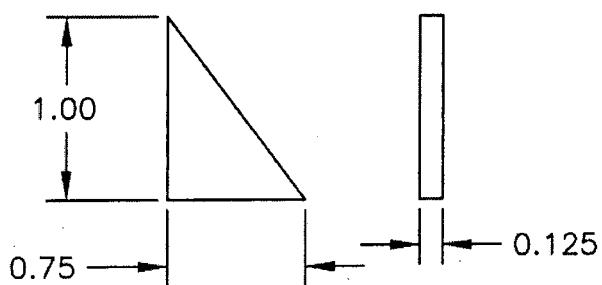
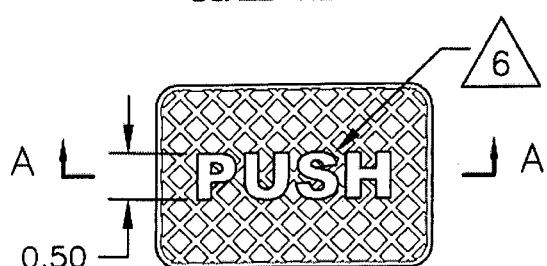
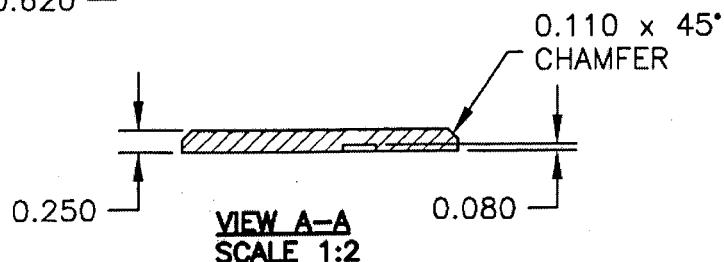
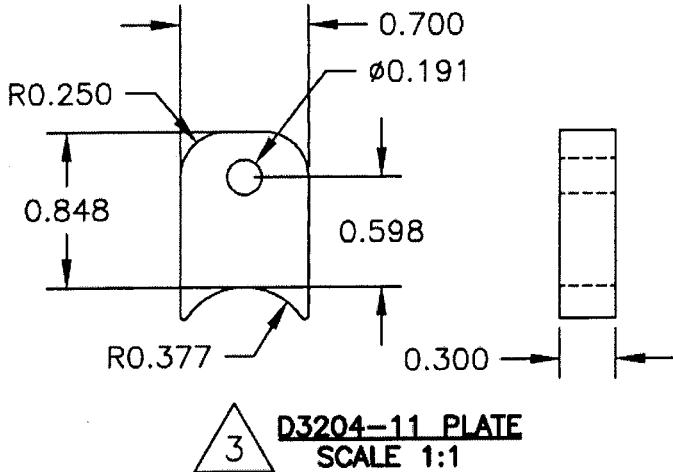
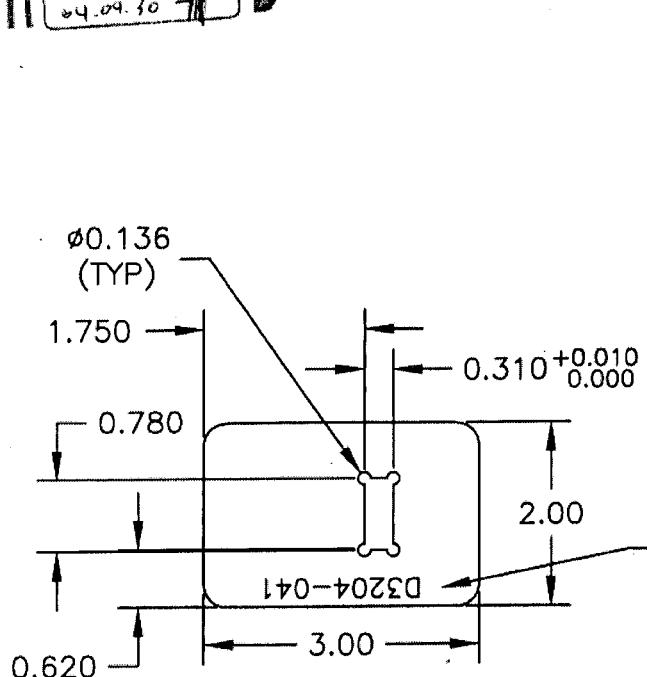
3 D3204-5 ARM
SCALE 1:2

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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.30

5 D3204-13 GUSSET SCALE 1:1

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13206-1 - stem

AN4-13A - Bolt

AN4-13A - Bolt